

Work Order ID 163510

Tuesday, June 27, 2017 1:26:46 PM

163510

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Item ID: 647.9701 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Sub Assembly
 Start Date: 6/27/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 7/3/2017 Req'd Qty: 3.00 ***3*** Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date **JUN 28 2017** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.9700	A1								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.48							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R RTV LOCTITE 598: <u>137757</u>								
	exp. date: <u>04/19</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.06							
Quality Control									

3 DAS 6 9-89 AUG 03 2017

3x DAS 36 9-89 17/05/17

3 DAS 38 9-89 AUG 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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140	Identify as per dwg & Stock Location <u>ceko</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

140

Packaging

Memo

0.03

Packaging

IDENTIFY AS PER IAW MPP-120

3

DAS
6
9-89

AUG 15 2017

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.30

Quality Control

UM 8/15/17

DAS
21
9-89

AUG 21 2017

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 163510

163510

Parent Item: 647.9701

647 9701

Parent Item Name: Lower Cutter Sub Assembly

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 13-03-21 JLM VERIFIED BY:DD IPP
REV:B 14.08.27 AS PER REVA2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.9710 *647 9710* Lower Body		Manufactured	No			110	Each	18.0000	1	3			DA 9-8
									**	165289		AUG 09 2017	

Location	Loc Qty	Loc Code
CCK077A	18	
128498	5	
130001	13	

MS27039-08-19

Purchased

No

110

Each

283.0000

6

18

MS27039-08-19

Screw

**

AUG 09 2017

Location	Loc Qty	Loc Code
GA	30	
m135948	26	
m137178	4	
ST277	253	
m137464	153	
m137851	100	

138045

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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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647 9701

Parent Item Name: Lower Cutter Sub Assembly

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 3.00

Required Qty: 3.00

NAS1149FN832P

Purchased

No

110

Each

2,530.000

12

36

NAS1149FN832P

Washer

**

AUG 09 2017

Location

Loc Qty

Loc Code

GA

358

M135058

208

M136182

40

M136866

110

ST260a

1500

M137820

1500

ST263

672

M137412

672

MS21042L08

Purchased

No

110

Each

834.0000

6

18

MS21042L08

Nut

**

AUG 09 2017

Location

Loc Qty

Loc Code

GA

100

m135274

6

m135978

94

ST303

734

m137391

160

m137464

224

m137736

250

m137851

100

646.9711

Manufactured

No

110

Each

0.0000

2

6

646 9711

Blade

**

163171

AUG 09 2017

AUG 09 2017

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